

Work Order ID 77651

77651

Page 1

December-14-11 10:36:57 AM

Item ID: D3272-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step
 Start Date: 14/12/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 15/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/12/14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								

100 0.00
100 Large Fab
 Large Fab Memo 0.00
 Large Fab ***SQUARE ONE END BEFORE CUTTING OTHER END***
 1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A
 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.
 3-Deburr

Ac 12.01.03

110 QC6- Inspect dimensions to drawing 0.00
110
 QC Memo 0.00
 Quality Control

8/12/03

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>W44</u>	0.00							
120									
Packaging	Memo	0.00				10	0		
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

OK 12/01/03
 MK
 12-01-03

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Picklist Print

December-14-11 10:37:00 AM

Page 1

Work Order ID: 77651

77651

Parent Item: D3272-1

D3272-1

Parent Item Name: Step

Start Date: 14/12/2011

Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	126.0200	1	10			

D2622-120C

Step Extrusion

**

Ac 12-1-02

Location	Loc Qty	Loc Code
HALL	17.02	
46910	2	
64409	6	
66970	7.7	
68293	0.5	
72131	0.82	
WA013	109	
<u>75781</u>	109	

X10

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NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *77651*

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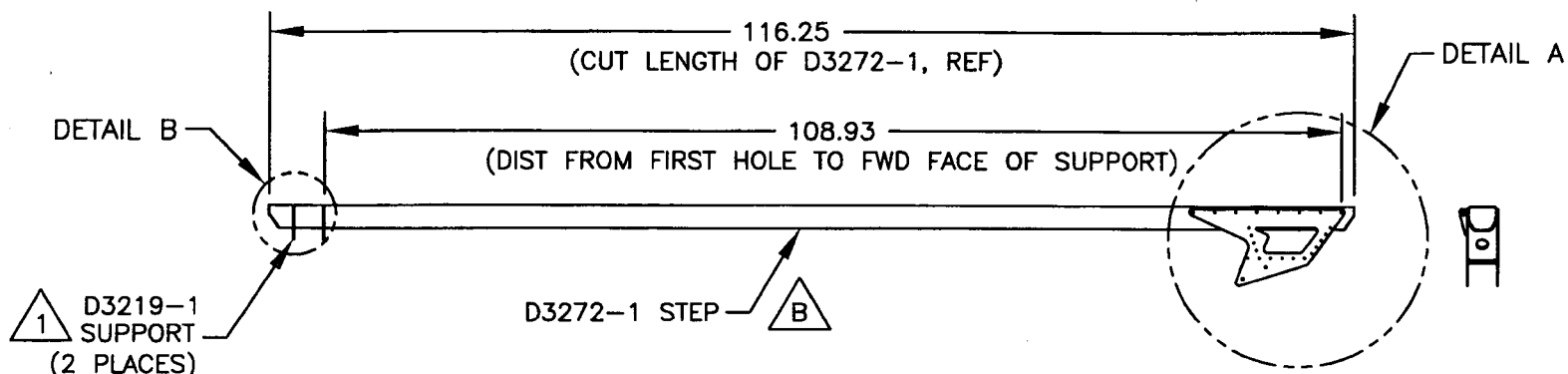
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DART

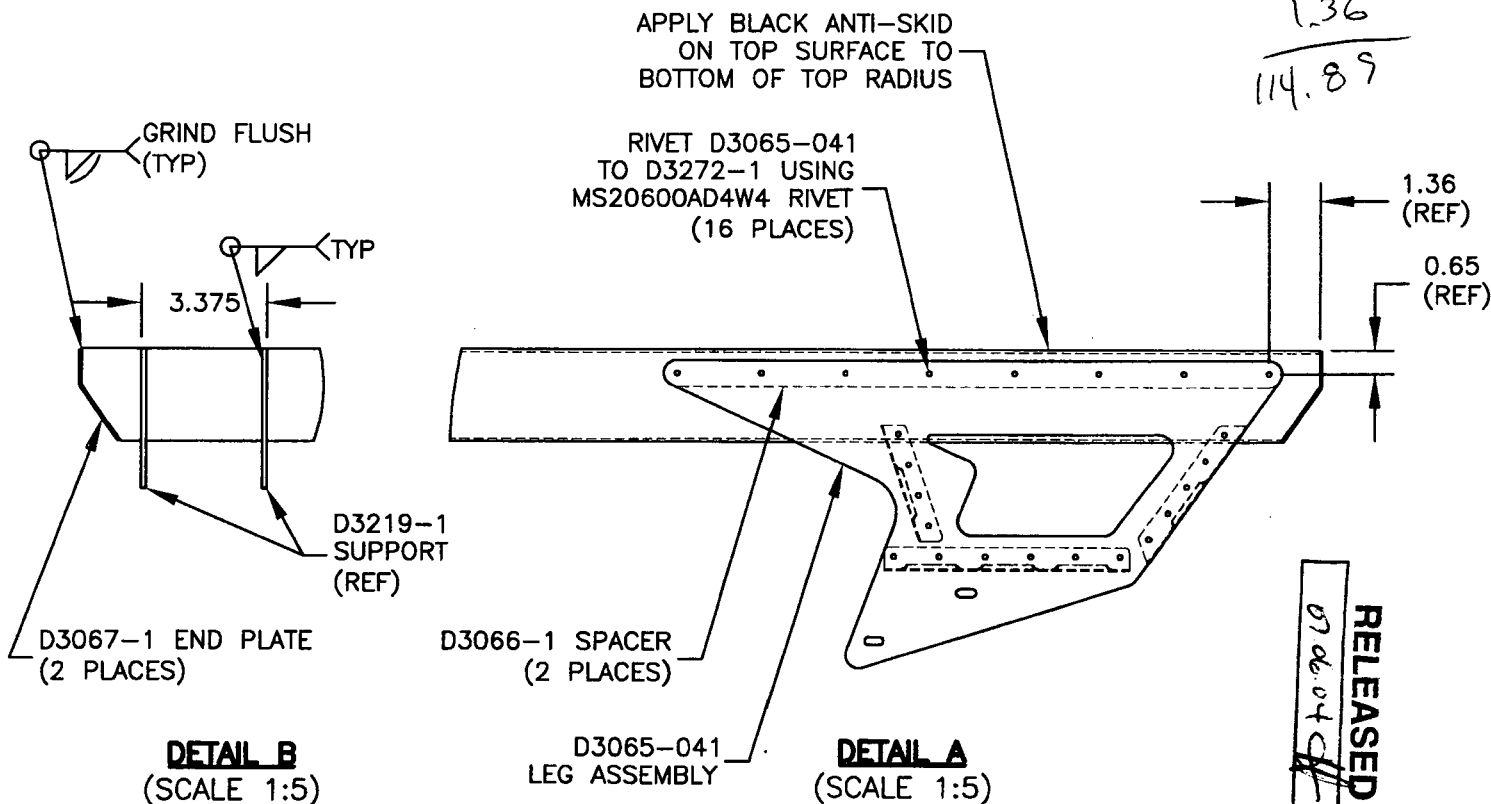
DESIGN	90	DRAWN BY	10	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	10	REV. B
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	

77651



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

411
116.25
1.36
114.89



RELEASED
07.06.04

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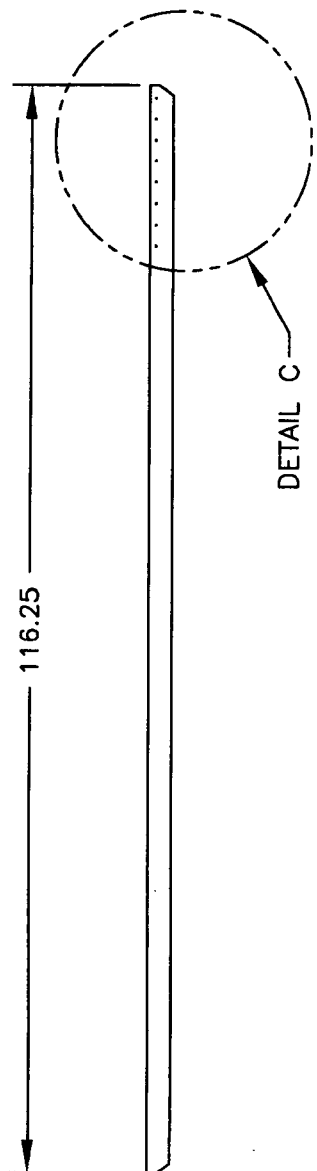
NOTE: Date & initial all entries

50
AW
C



DESIGN <i>qp</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

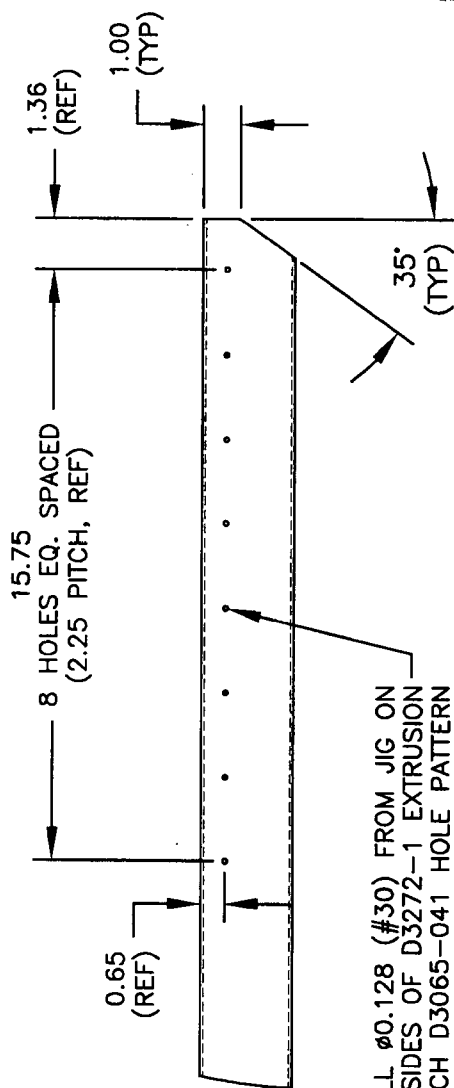
77657



DETAIL C
B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)

RELEASED

07.06.04 *[Signature]*



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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